S.O. No. :

Type

: A119 STEP WELDMENT LH

Date:

User:

Monday, 25/05/2009 1:30:18 PM

Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Job Number : 48174A **Estimate Number** : 10122

P.O. Number

This Issue

: 25/05/2009 : NC

Prsht Rev. First Issue : //

: 46571A **Previous Run**

Written By

Checked & Approved By

Comment

: Est Rev :A

New Issue

: LARGE FAB ASSY

05-11-01 JLM

Project Number

Part Number

Drawing Name

: D3043 REV A : N/A

: D3043041

Drawing Revision

Drawing Number

Material

Due Date : 10/06/2009 Qty:

Um:

Each

Additional Product

Job Number:

Seq. #: 1.0

2.0

Machine Or Operation:

Comment: Qty.:

1.0000 Each(s)/Unit Total:

4.0000 Each(s)

Pick:D2622-120 extrusion Batch: 46910

D2622120C

LARGE FAB 1

LARGE FABRICATION RESOURCE 1

INSPECT WORK TO CURRENT STEP

Description:

Step Extrusion

Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622-120 extrusion to 120.00" long as per Dwg D3043 using cutting table setup DT8185-G

2-Deburr and bevel ends for welding

QC5

Comment: INSPECT WORK TO CURRENT STEP

4.0

3.0

D2734

Comment: Qty.:

Step End Plate

2.0000 Each(s)/Unit Total:

8.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2734 End Cap

5.0

D30401

2.0000 Each(s)/Unit Total:

8.0000 Each(s)

Pick:

Comment: Qty.:

Qty Part Number Description Batch

2 D3040-1

Mounting Lug 34/2849

Page 1

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W/O:		WORK ORDER CHANGES									
·DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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Part No: PAR #	: Fault Category:	NCR: Yes No DQA:	Date:
Resolution:	Disposition:	QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section 6	3	Verification	A				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC inspector			
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NOTE: Date & initial aff-entries

Date: Monday, 25/05/2009 1:30:18 PM IJser: Julie Dawson **Process Sheet** Drawing Name: A119 STEP WELDMENT LH Customer: CU-DAR001 Dart Helicopters Services Job Number: 48174A Part Number: D3043041 Job Number: Seq. #: **Machine Or Operation:** Description: 6.0 D30403 Mounting Lug Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s) Qty Part Number Description Batch 2 D3040-3 Mounting Lug 3 42945 LARGE FAB 1 LARGE FABRICATION RESOURCE 1 7.0 Comment: LARGE FABRICATION RESOURCE 1 1-Weld 1 End Cap & Mounting Lugs as per QSI 004 & Dwg D3043 Using DT8802 AL ROD Batch: <u>M//0/30</u> M//0972 2-Grind Fwd End Cap weld flush 8.0 QC9 VISUAL WELDING INSPECTION **Comment: VISUAL WELDING INSPECTION** INSPECT WORK TO CURRENT STEP 9.0 QC5 Comment: INSPECT WORK TO CURRENT STEP HAND FINISHING RESOURCE #1 10.0 HAND FINISHING1 Comment: HAND FINISHING RESOURCE #1 1-Chemical Conversion Coat as per QSI 005 4.1 LARGE FABRICATION RESOURCE 1 11.0 LARGE FAB 1 Comment: LARGE FABRICATION RESOURCE 1 1-1-Weld 1 End Cap as per QSI 004 & Dwg D3043 AR AL ROD Batch: MIIO130 2-Inspect for foreign object as per QSI 024 3-Grind Fwd End Cap weld flush

Form: rprocess

Page 2

Dart A	erospa	ce Ltd
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w/o: 48	174A	Pan Changes WORK ORDER CHANGES	<u>'</u>				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
9/6/8	业 10.1	Moder cleminal cont / Aloxin QC+3 -SAD 09-06-08 porm CHANGE	1 / /	09/06/18		614.18	Orlobes
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Part No:		PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
	Resolution:		Disposition:	QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC Corrective Action Section B		Description of NC Corrective Action Section B		Verification	Approvol	Annroyal			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto			
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NOTE: Date & initial all entries

Date: Monday, 25/05/2009 1:30:18 PM Julie Dawson User: **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: A119 STEP WELDMENT LH Job Number: 48174A Part Number: D3043041 Job Number: Seq. #: **Machine Or Operation:** Description: VISUAL WELDING INSPECTION 12.0 QC9 Comment: VISUAL 13.0 QC5 INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP HAND FINISHING RESOURCE #1 14.0 Comment: HAND FINISHING RESOURCE #1 1-Touch up Chemical Conversion Coat as per QSI 005 4.1 15.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVER Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION Inspect alodine 16.0 POWDER COATING POWDER COATING M111 472 **Comment: POWDER COATING** Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 10:00 Au START TIME: **OVEN TEMPERATURE:** FINISH TIME: 17.0 HAND FINISHING1 HAND FINISHING RESOURCE #1 m 1/10/3 Comment: HAND FINISHING RESOURCE #1 1-Wing Walk as per Dwg D3043 and QSI 005 4.4 18.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Dart Aerospace	: Ltd
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W/O:			WC	ORK ORDER CHANG	SES					
DATE STEP		PROCEDURE CHANGE By Da				Date Qty Approv			Approvai	
Part No	:	PAR #:	Fault Cate	jory:	NCR: `	Yes N	lo DQ	A :	_ Date: _	
	Re	solution:	Disposition	:	QA: N/	C Clo	sed:		Date: _	
NCR:		•	WORK ORDE	R NON-CONFORM	ANCE (I	(CR)				
DATE	STEP	Description of NC			tion B	: O	Verific	ation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date	Secti	on C	Chief Eng	QC Inspector
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NOTE: Date & initial all entries

Monday, 25/05/2009 1:30:18 PM Date: Julie Dawson User: **Process Sheet** Drawing Name: A119 STEP WELDMENT LH Customer: CU-DAR001 Dart Helicopters Services Job Number: 48174A Part Number: D3043041 Job Number: Seq. #: Description: Machine Or Operation: 19.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 20.0 QC21 mf 09-06-17 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

W/O:	rospace Ltd		WORK ORDER	CHANGES			7	
DATE	STEP	PR	OCEDURE CHANGE		By Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					:			
					1 10 10 10 10 10 10 10 10 10 10 10 10 10			
Part No		PAR #:	Fault Category:	NCR: Ye	es No DQ	A:	Date: _	
Resolution:			Disposition:		QA: N/C Closed:			
NOD			WORK ORDER NON-COM					

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
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	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector		
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	48/74
DART ALROOT AGE LTD		
Description: A 119 Stop welcoment RLH	Part Number:	D3043-E41 /
DT#8808		
Inspection Dwg: D3043 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
120.00"	2.030"	120.00	_/		TAPE M.	
115 48 4	7.030	10.50			TAPE M.	1
0.875	+ 030" /	0979	<u> </u>		Tape M.	,
9657"	2030"	96.57	V		TAPE Me	
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Measured by:		Audited by:		Prototype Approval:	
Date:	oflowlost	Date:	Lower	Date:	

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Rev	Date	Change	•	Revised by	Approved
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Α		New Issue		KJ/JLM	<u> </u>







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С	HECKED M	APPROVED	DRAWING NO.	REV. A
	₩		D3043	SHEET 1 OF 2
D,	ATC		TITLE	SCALE
0	1.06.28	3	A119 STEP WELDMENT	NTS
	A	01.06.28	NEW ISSUE	

PARTS LIST:

Qty -041	Qty -043	Part Number	Description	
Х		D3043-041	STEP WELDMENT, LH	
	Х	D3043-042	STEP WELDMENT, RH	
1	1	D2622-120	STEP EXTRUSION	
2	2	D3040-1	MOUNTING LUG	
2	2	D3040-3	MOUNTING LUG	
2	2	D2734	ENDPLATE	_
		1		

NOTES:

- 1) MANUFACTURE FROM D2622-120 EXTRUSION
- 2) WELD PER DART QSI 004. ALL WELDS SHOULD BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004
- 3) FINISH: ACID ETCH & ALODINE ASSEMBLY PER DART QSI 005 4.1 POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT TOP SURFACE OF STEP TO BOTTOM OF TOP RADIUS PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DESIGN DRAWN BY DART AEROSPACE USA, INC. PORT HADLOCK, WA DRAWING NO. CHECKED A APPROVED REV. A D3043 SHEET 2 OF 2 DATE TITLE SCALE 01.06.28 A119 STEP WELDMENT 1:5 01.06.28 **NEW ISSUE** 120.00 (DOES NOT INCLUDE ENDPLATES) --D3040-1 MOUNTING LUG 11.4 **ENSURE HOLES** (2 PLACES) (TYP) **ALIGN** -D3040-3 MOUNTING LUG (2 PLACES) 1.00 -D2734 ENDPLATE (TYP BOTH ENDS) 0.875 +0.030 (TYP) 96.57 - 10.48 -VIEW A-A: D3043-041 LH STEP WELDMENT - 120.00 (DOES NOT INCLUDE ENDPLATES) -----D3040-1 MOUNTING LUG ENSURE HOLES (2 PLACES) (TYP) **ALIGN** -D3040-3 MOUNTING LUG (2 PLACES) 1.00 D2734 ENDPLATE 45 (TYP BOTH ENDS) 0.875 +0.030 (TYP) SHO! COPY - 96.57 - 10.48 *-*-RETURN TO

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VIEW A-A: D3043-042 RH STEP WELDMENT